

Date: Tuesday, 1/23/2007 7:33:40 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIGHT ARM WELDMENT
Job Number : 30400	
Estimate Number : 11875	
P.O. Number : <i>N/A</i>	Part Number : D33545
This Issue : 1/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3354 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 29903	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/29/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 4 Um: Each
Comment : est rev. A 06.01.14 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X0200	1010-1025 BAR
-----	-----------------	---------------



Comment: Qty.: 0.4148 f(s)/Unit Total: 1.6590 f(s)

1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 0.750"

Batch: *M17270**J.F. 07/03/07 (7)*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 4.625" long

*J.F. 07/03/07**(7)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA612 and Dwg D3353

2- Debur

*J.F. 07/03/07**(7)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 07/03/07**(7)*

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*SA 07.03.07**(7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RIGHT ARM WELDMENT

Job Number: 30400

Part Number: D33545

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Handwritten signature and date 07/03/08 with circled 7

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

Handwritten date 07/03/08

Job Completion



Handwritten signature and date 07/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

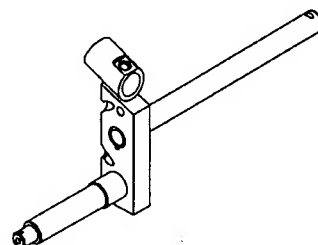
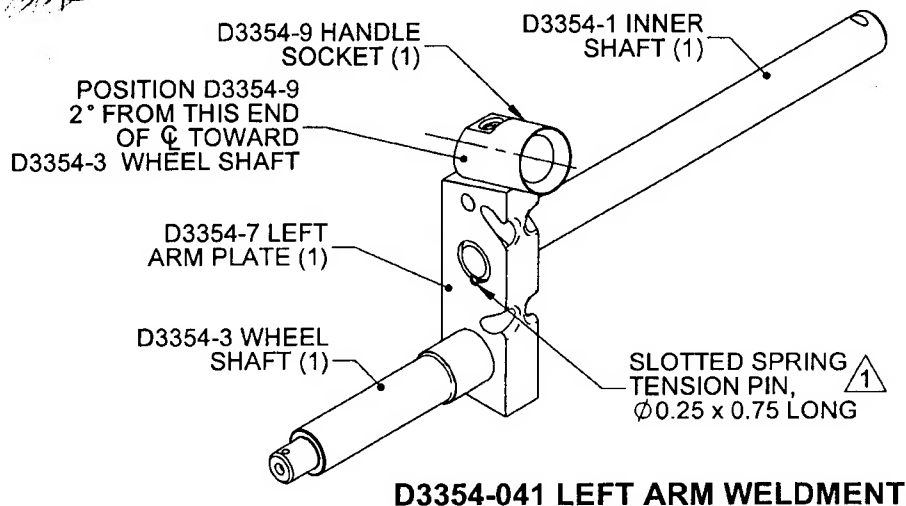
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

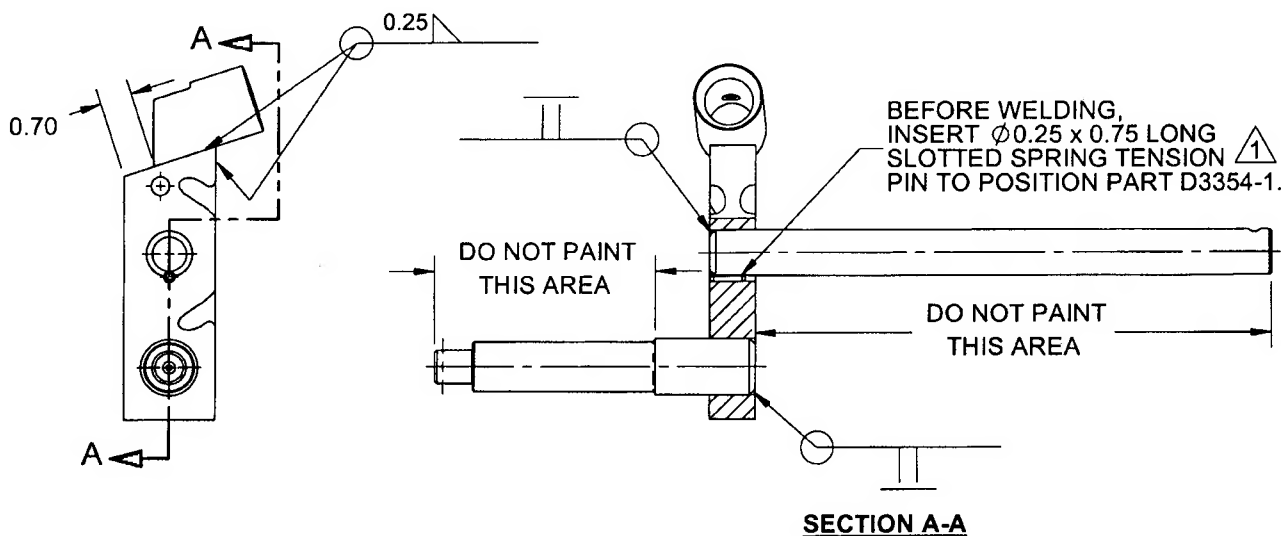


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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:4
A	04.12.13	NEW ISSUE	

RELEASED
86/03/07



**D3354-042 MIRROR
ARM WELDMENT**



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

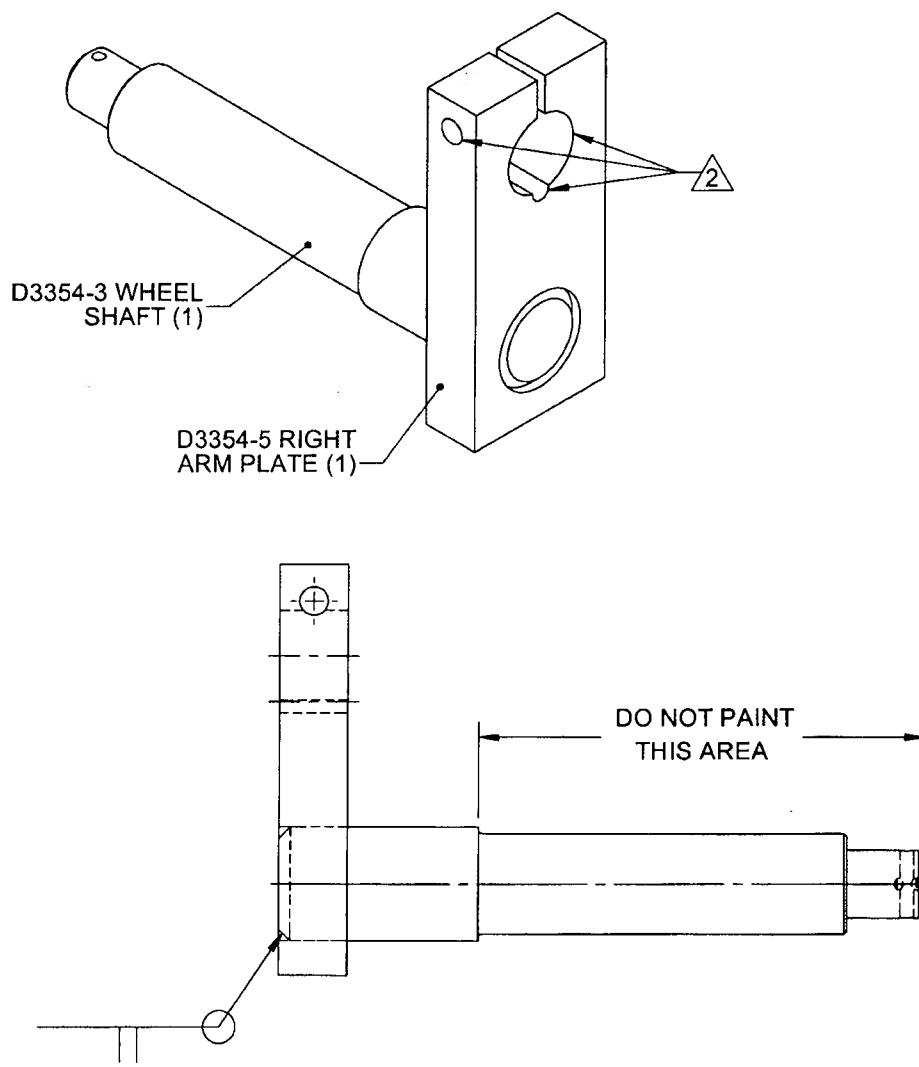
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

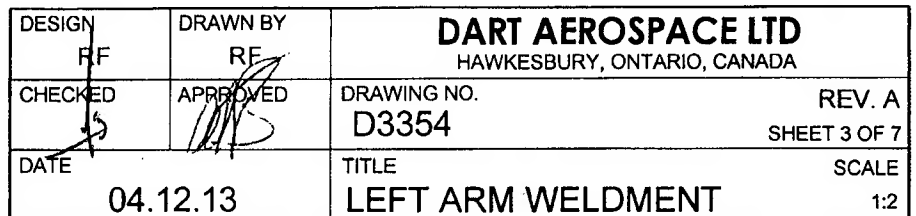
RELEASED
06/03/19
[Signature]**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3 WITHOUT NOTICE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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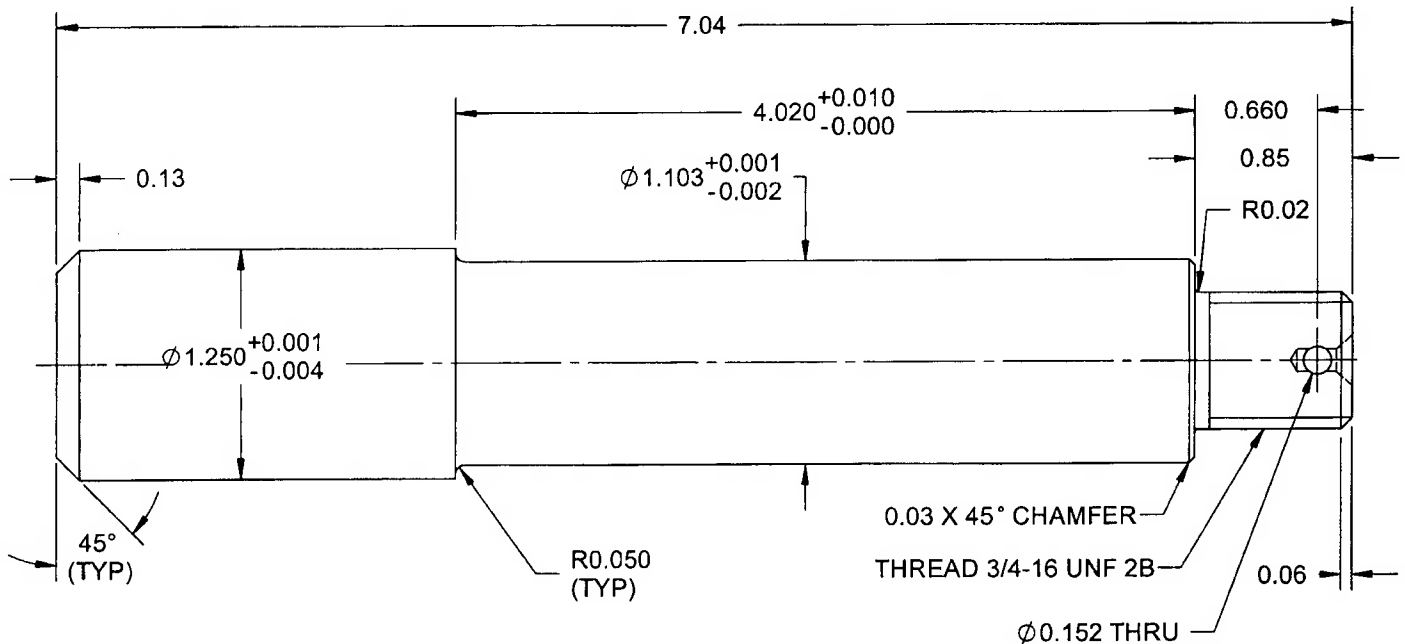
1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS#-G41400 ROUND BAR, Ø1.250 (REF. DART SPEC. M4140H1R)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 04.12.13	TITLE LEFT ARM WELDMENT	SCALE 1:1	

RELEASED
[Signature]**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

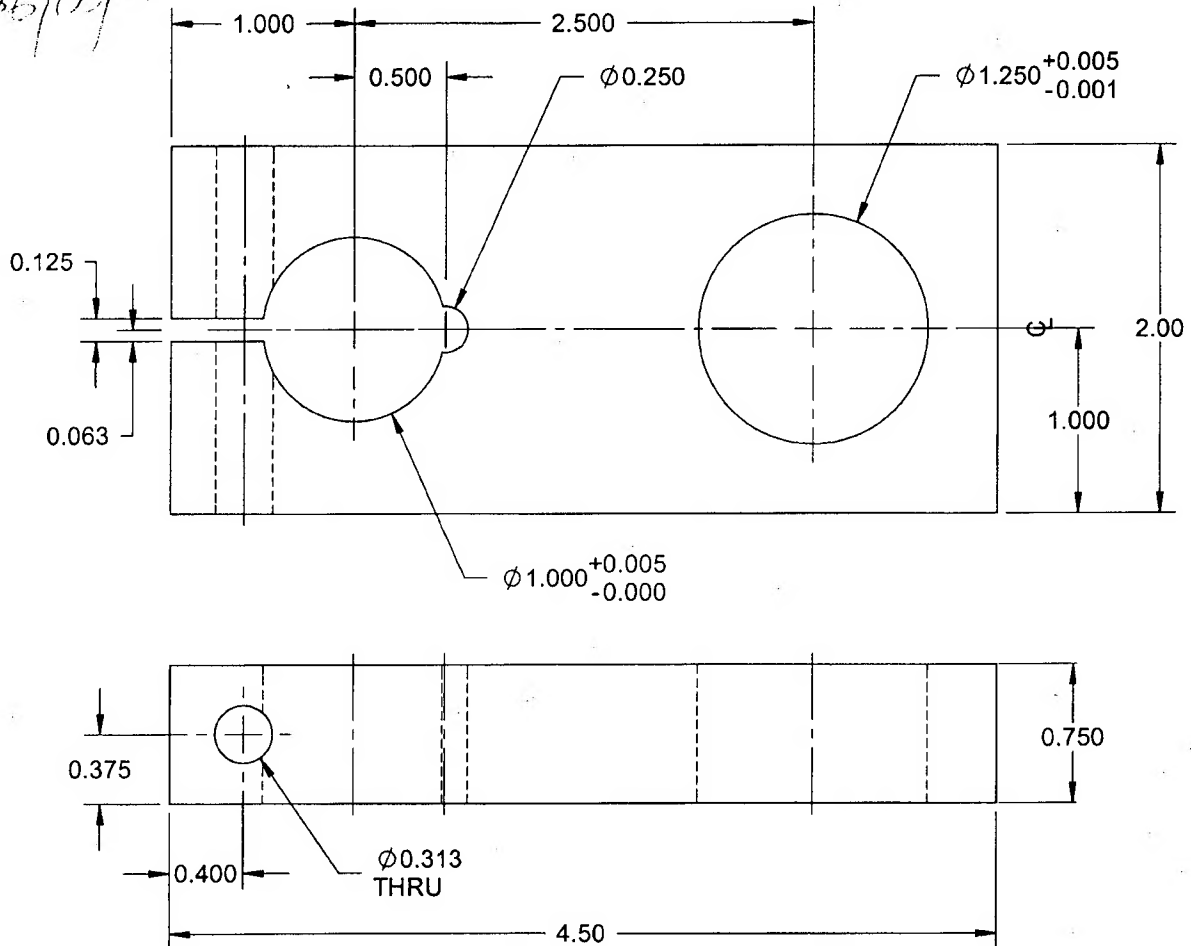
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
26/03/14**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

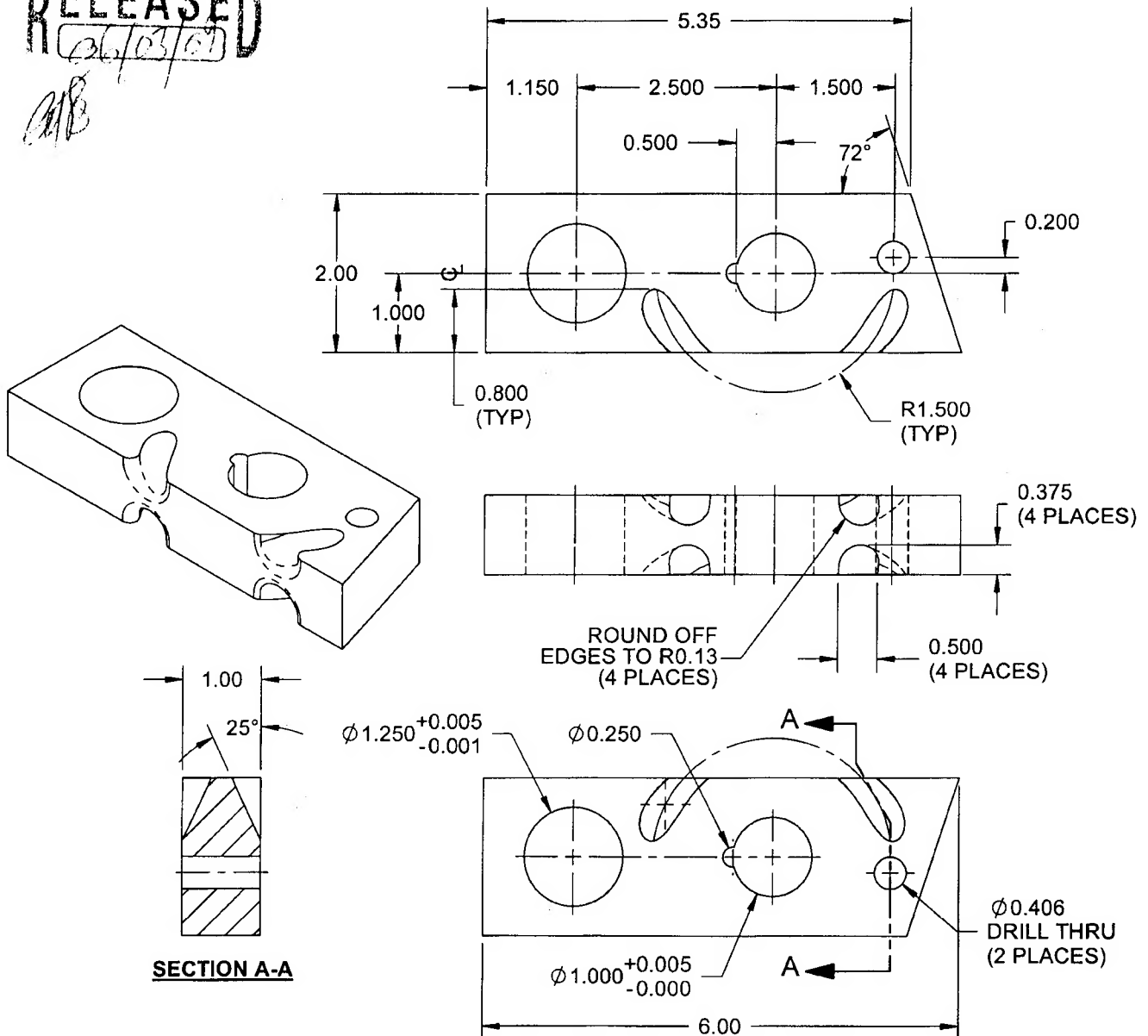
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
26/03/08**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

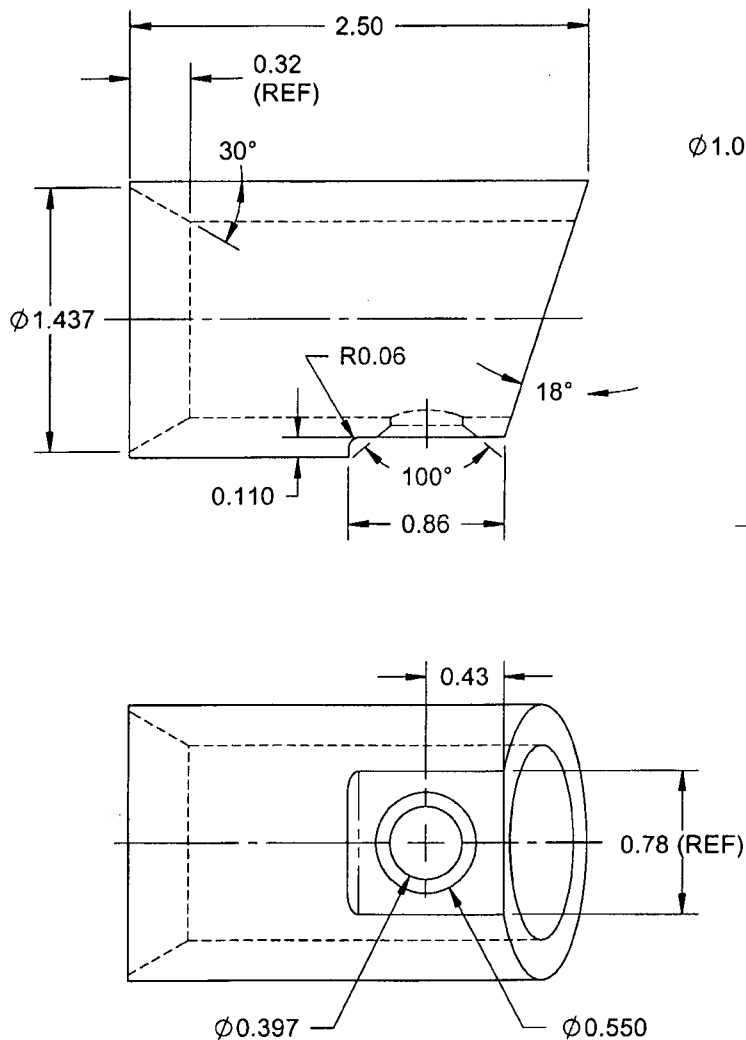
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

**RELEASED**
06/03/09**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ENGINEERING ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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